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K6A 1K7
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000615

D044-715-011
Job Sheet 180527



Part No: D044-715-011

Job Qty: 1 ea

Part Name: R44 Cargo Mirror



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/9/18

Job Tracking No:

Due Date: 7/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3243 REV A, IIN-D044-715 REV A IPP Rev:A 04.02.18 New issue KJ/JLM IPP Rev:B 06-04-28
Manufactured on Water Jet JLM IPP Rev:C 08-06-10 as per ECN1195p DD verified by:EC IPP Rev:D 11.05.04
remove FE-032-EF DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	1 Ea	7/30/18	7/30/18	0.00	0.00	Start Up Stores/Pkg-1			JUL 23 2018
110	Packaging	1 pcs	7/30/18	7/30/18	0.00	0.00	Packaging1-1			AUG 02 2018
120	QC	1 pcs	7/30/18	7/30/18	0.00	0.00	QC4			AUG 02 2018
125	DC	1 pcs	7/30/18	7/30/18	0.00	0.00	DC			AUG 03 2018
130	Packaging	1 pcs	7/30/18	7/30/18	0.00	0.00	Packaging3-1			AUG 03 2018
140	QC21-FG	1 Ea	7/30/18	7/30/18	0.00	0.00	QC21			AUG 03 2018

Part Op 125 - Photocopy bluefile & type labels per PPPD044-715-011 CHG003
Descriptions: 130 - Identify and pack for shipping as per PPP D044-715-011 LOCATION: FG011

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
ALS4-1032-130	Rivnut	4 Ea (4 ea)	90-Start up Operation	5008959
AN3-4A	Bolt	4 Ea (4 ea)	90-Start up Operation	5060003
AN526C1032R10	Screw	4 Ea (4 ea)	90-Start up Operation	5071664
D1048	Clamp	2 Ea (2 ea)	90-Start up Operation	5006136
D1049	Saddle	2 Ea (2 ea)	90-Start up Operation	5007627
D2010-104	Arm	1 Ea (1 ea)	90-Start up Operation	5075938
D2011-101	Mirror 6"	1 Ea (1 ea)	90-Start up Operation	5083122
D3243-041	Bracket	1 Ea (1 ea)	90-Start up Operation	5089218
NAS1149D0332J	Washer	4 Ea (4 ea)	90-Start up Operation	5035396

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	ALS4-1032-130	4	13,229	0
	AN3-4A	4	265	0
	AN526C1032R10	4	162	0
	D1048	2	14	0
	D1049	2	0	0
	D2010-104	1	0	0
	D2011-101	1	31	0
	D3243-041	1	9	0
	NAS1149D0332J	4	1,535	0

5098730

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____ Step #: _____

MRB (QSI042) Approval

Description Work Order I _____ _____ _____	Job No: 180527 Mfg Date: 08/02/18	Change No: CHG003 Operation: Packaging Revision: _____ Serial No/Batch: S098730 PART NO: D044-715-011	Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																			
	R44 Cargo Mirror 																																					
	Container No: S098730 																																					
	DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																					
	Root Cause <table border="1"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> <td>Pr ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Be ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Ce ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cr ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td></td> </tr> </table>			Environment ☐	No Re-verification ☐	Pr ☐	Design ☐	Operator ☐	Be ☐	Doc/Data ☐	Offset/Setup ☐	Ce ☐	Equip/Tooling ☐	Supplier ☐	Cr ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐
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Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____					

Part Specifications

Specifications could not be found.

Plex 7/9/18 2:39 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

2. GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D044-715.

3. INSTALLATION INSTRUCTIONS

To install the Dart Cargo Mirror Installation on the R44 skidtube:

1. Locate the D3243-041 Bracket with approximately 0.38" (10mm) space between the top of the skidtube and the bracket, as shown in Figure 2. Transfer drill the 4 holes from the bracket to the centerline of skidtube and enlarge to 10/64" (Ø0.297"). Deburr holes and wet install ALS7-1032-130 inserts using MIL-P-85582 or MIL-P-23377 primer.
2. Install the D3243-041 Bracket on the skidtube using the AN3 hardware. The bolts should be sealed with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing as per Figure 2.
3. Install remaining hardware per Figure 2 as required. Adjust the angle of the D2010-104 Arm and tighten the AN526C1032R10 screws to secure arm.
4. To adjust the mirror: loosen (DO NOT REMOVE) the three adjustment screws shown in Figure 2, reposition the mirror, then tighten the screws.

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-715-011 Cargo Mirror Installation	1.3 lb 0.59 kg	41.7 in 1.06 m	54.2 lb-kG 0.63 m-kG	32.0 in 0.81 m	41.6 in-lb 0.48 m-kG

5. PARTS LIST

REFERENCE ONLY

Qty	Part Number	Description
X	D044-715-011	CARGO MIRROR INSTALLATION
2	D1048	Clamp
2	D1049	Saddle
1	D2010-104	Arm
1	D2011-101	Mirror
1	*D3014-1	Locknut
1	D3243-041	Bracket
4	ALS7-1032-130	Insert (or AKS7-1032-130, AKS4-1032-130, ALS4-1032-130)
4	AN3-4A	Bolt
4	AN526C1032R10	Screw (or AN526-1032R10)
4	AN960JD10L	Washers
1	*AN960JD416L	Washer

* PARTS ARE INCLUDED WITH D2011-101 MIRROR

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Revision: **A**

Date: 04.01.20

REFERENCE ONLY

Change Record

Part Number D044-715-011
Description D44 CARGO MIRROR

Page 1 of 1[illegible]

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Rev. A